

Work Order ID 142165

March 01, 2016 11:56:52 AM

D 4840-041
B 142165
REV. A

142165

Ship ASAP
Mar 17 ~~21~~

Page 1

Item ID: D4840-041
Revision ID:
Item Name: Upper Cutter Assembly
Start Date: ~~3/1/2016~~ Mar 17 Start Qty: 3.00 *3*
Required Date: 3/11/2016 Req'd Qty: 3.00 *3*
Reference: Mar 21
Accept
N900040100
Setup Start *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: Process Plan: SH Date: 0160301 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4840	REV A								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces.								
	A/R LOCTITE 598: 140260								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

3x 16/03/21 DAS 36 9-89

(3) 38 9-89
MAR 22 2016

DQA:

Date: 16.04.13



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/03/30

Work Order update only ☐

Work Order: 142165		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. D4840-041		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. 16-5689		Scrap ☐		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: 16-03-13	Step #: 120	QTY Effective: 4				MRB (QSI042) Approval DAS 9 9-89 16-03-13			
Description Work Order Deviation				Disposition				Completed By DAS 41 16-3-18 9-89	
During installation, operator notice that D4823-1 was not too drawing (measurement .70" was .65"				rework D4823-1 B105011 qty 4 as per dwg D4823 Rev A				Lead hand / Supervisor Approval Verification DAS 33 9-89 MAR 18 2016	
P.C. operator. Miss at QC2 and QC3				alodine & prime B# 133399				QC / QA Coordinator Approval PD 16-03-13	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☒				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER: ☐							

Work Order ID 142165***142165***

Page 2

Item ID: D4840-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Upper Cutter Assembly

Stop ***NS2***

Start Date: 3/1/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 3/11/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location CCK045

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

3
MAR 22 2016MUS
MAR 22 2016MUS
MAR 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

"March 01, 2016 11:56:58 AM

Page 1

Work Order ID: 142165

142165

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 3/1/2016

Required Date: 3/11/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4823-1 *D4823-1* Upper Cutter Deflector		Manufactured	No				Each	5.0000		3			DAS 6 9-89

**

Location Loc Qty Loc Code

cck127

4

105011

4

cck136a

1

137368

1

D4824-1

Manufactured

No

Each

1.0000

3

DAS
6

D4824-1

Upper Cutter Mount

**

Location Loc Qty Loc Code

cck127

1

137369

1

D4838-2

Manufactured

No

Each

0.0000

3

D4838-2

Upper Cutter Body, RH

**

D4838-1

Manufactured

No

Each

4.0000

3

D4838-1

Upper Cutter Body, LH

**

Location Loc Qty Loc Code

CCK128

4

137371

4

DAS
6
9-89

MAR 16 2016

0000

Picklist Print

March 01, 2016 11:56:58 AM

Page 2

Work Order ID: 142165

142165

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 3/1/2016

Required Date: 3/11/2016

Start Qty: 3.00

Required Qty: 3.00

D4839-1

Manufactured No

Each

37.0000

6

D4839-1

Blade

DAS
6
9-89

MAR 16 2016

Location

Loc Qty

Loc Code

CCK128

17

137690

5

138971

12

CCK129

20

141328

20

Each

1,040.000

42

MS27039-08-19

Purchased

No

MS27039-08-19

Screw

DAS
30
9-89

MAR 17 2016

Location

Loc Qty

Loc Code

CCK06

200

m134142

200

GA

677

m132930

84

m133077

22

m134063

571

over006

100

m134294

100

ST277

63

m133769

63

42

Picklist Print

March 01, 2016 11:56:58 AM

Page 3

Work Order ID: 142165

Parent Item: D4840-041

Parent Item Name: Upper Cutter Assembly

142165

D4840-041

Start Date: 3/1/2016

Required Date: 3/11/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149FN832P

Purchased

No

Each

3,671.000

84

DAS

30

9-89

MAR 17 2016

NAS1149FN832P

Washer

**

Location

Loc Qty

Loc Code

GA

1361

M133316

16

M133769

1345

ST260a

1200

M134257

1200

ST262

1110

M133709

1110

Each

1,387.000

42

DAS

30

9-89

MAR 17 2016

MS21042L08

Purchased

No

MS21042L08

Nut

**

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

161

m133134

3

m134063

158

OVER007

500

m134063

500

ST303

625

m133922

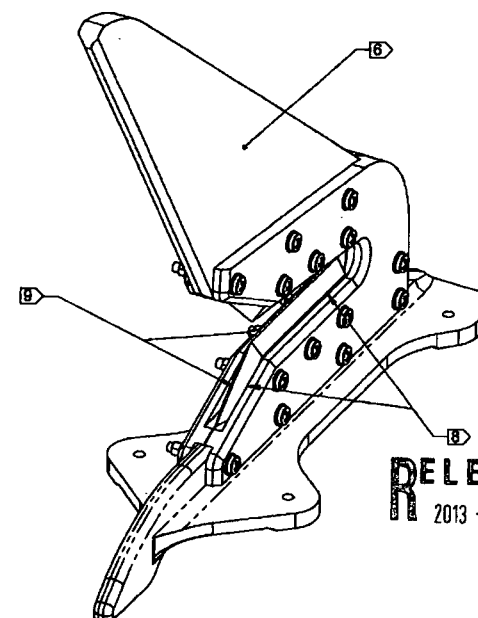
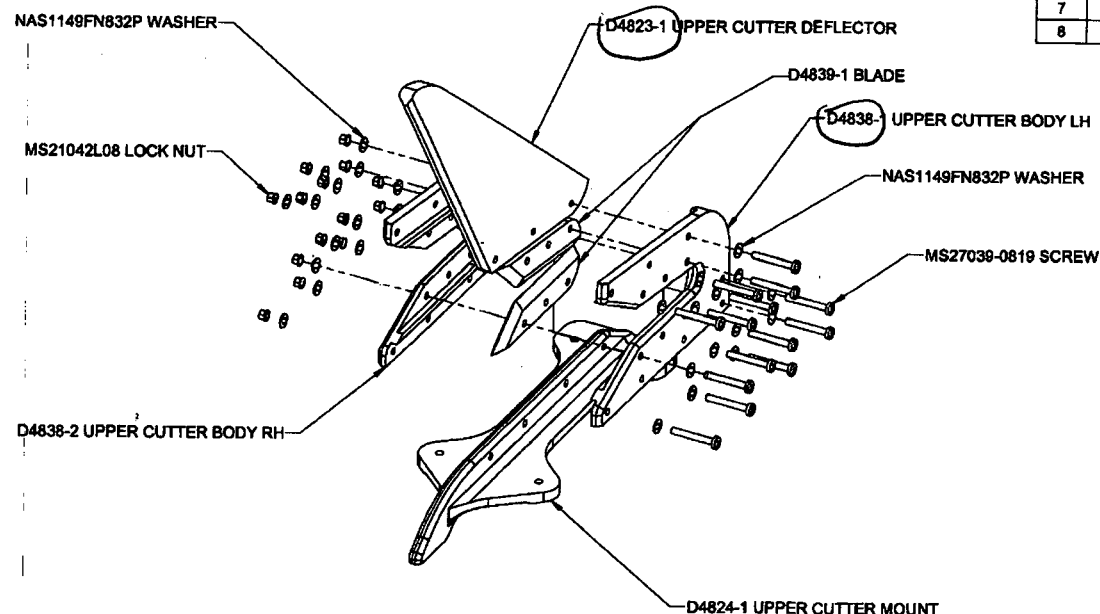
625

March 01, 2016 11:56:59 AM

Shop Packet Print

Page 3

ITEM	QTY -041	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4838-1	UPPER CUTTER BODY LH
4	1	D4838-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN960C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT



D4840-041 UPPER CUTTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

20160301

SH 142165

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION		BY DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	21	D4840	SHEET 1 OF 1
APPROVED	12	TITLE	SCALE
DE APPR.	11	UPPER CUTTER ASSY	NTS
DATE	13.05.23	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	